

Date: Wednesday, 06/08/2008 9:20:01 AM
 User: Julie Lecocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP RH (FOLDING)
 Job Number : 40998 -24
 Estimate Number : 12568
 P.O. Number :
 This Issue : 06/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412630034
 First Issue : 06/08/2008 Type : LARGE FAB ASSY Drawing Number : IIN D412-630
 Previous Run : 40269 Project Number : N/A
 Written By : Drawing Revision : L
 Checked & Approved By : JLM 08-806 Material :
 Comment : Est. Rev:A New Issue 06-11-08 JLM Due Date : 28/08/2008 Qty: 5 Um: Each
 est rev B ecn1019, added D2807-041 EC verified by:DD

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

S o l a / e

| | | |
|-----|----------|--------|
| 2.0 | D2012107 | Clevis |
|-----|----------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1 | D2012-107 | Clevis | 40274 |

AS 08/08/07 (x5)

| | | |
|-----|----------|------------------|
| 3.0 | D2803042 | Bracket Assembly |
|-----|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------------|-----------|
| 1 | D2803-042 | Bracket Assembly RH | 34017 x 2 |

-3 ordered

AS 08/08/07 (x5)

| | | |
|-----|----------|------------------|
| 4.0 | D2804042 | Bracket Assembly |
|-----|----------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------------|-------|
| 1 | D2804-042 | Bracket Assembly RH | 35827 |

AS 08/08/07 (x5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch: 35751

AS 08/08/07 (KS)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2 | D2813 | Washer |

Batch: 34020

AS 08/08/07 (KS)

7.0

D3562042

Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

| Qty | Part Number | Description |
|-----|-------------|------------------|
| 1 | D3562-042 | Step Weldment RH |

Batch: B41246

AS 08/09/02 (KS)

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 4 | D3395-1 | Bushing |

Batch: 33578 x14

AS 08/08/07 (KS)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 2 | AN3C21A | Bolt |

Batch: 101189

AS 08/08/07 (KS)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|------|
| 10.0 | AN8C16 | Bolt |
|------|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN8C16 | Bolt | 1010066 |

AS 05/08/07 (X5)

| | | |
|------|---------|-----|
| 11.0 | AN310C8 | Nut |
|------|---------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN310C8 | Nut | M106431 |

AS 08/08/07 (X5)

| | | |
|------|------------|------------|
| 12.0 | MS24665302 | Cotter Pin |
|------|------------|------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------------------|---------|
| 2 | MS24665-302 | Cotter Pin (or AN380C3-4) | M106763 |

AS 08/08/07 (X5)

| | | |
|------|-----------|--------|
| 13.0 | NAS1515H3 | Washer |
|------|-----------|--------|



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 6 | NAS1515H3 | Washer | M10761 |

AS 08/08/07 (X5)

| | | |
|------|------------|--------|
| 14.0 | NAS1515H5L | WASHER |
|------|------------|--------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------------|
| 4 | NAS1515H5L | Washer | M108964 (3x) |

AS 08/08/07 (X5)

Process Sheet

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Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H8

Washer

M106575

JS 08/08/07 (X5)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

4

MS21043-3

Nut

M108673

JS 08/08/07 (X5)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty

Part Number

Description

Batch

2

MS24693-C280

Screw (or MS24694-C565)

M101340

JS 08/08/07 (X5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

EP 08/09/07 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/07 (X2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

35630

JS 08/09/02 (2)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

34019

JS 08/09/02 (2)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

36521 x1
41029 x1

JS 08/09/02 (2)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

34025

JS 08/09/02 (2)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M107242

JS 08/09/02 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|---|--------|------|
| 1 | AN4C6A | Bolt |
|---|--------|------|

| | | |
|------|---------|------|
| 26.0 | AN4C10A | Bolt |
|------|---------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | AN4C10A | Bolt | M101189 |

AS 08/09/02 (X2)

| | | |
|------|---------|------|
| 27.0 | AN4C15A | Bolt |
|------|---------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN4C15A | Bolt | M107082 |

AS 08/09/02 (X2)

| | | |
|------|---------|---------|
| 28.0 | AN44C7A | Eyebolt |
|------|---------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 1 | AN44-C7A | Eyebolt | M100446 |

AS 08/09/02 (X2)

| | | |
|------|---------|------|
| 29.0 | AN5C15A | Bolt |
|------|---------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 2 | AN5C15A | Bolt | M105125 |

AS 08/09/02 (X2)

| | | |
|------|-----------|--------|
| 30.0 | NAS1515H4 | Washer |
|------|-----------|--------|



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|---------|
| 7 | NAS1515H4 | Washer | M108552 |

AS 08/09/02 (X2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M108334

JS 08/09/02 (K2)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M108672

JS 08/09/02 (K2)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M108583

JS 08/09/02 (K2)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/09/02 (K2)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

Rev A

JS 08/09/02 (K2)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/09/02 (K2)

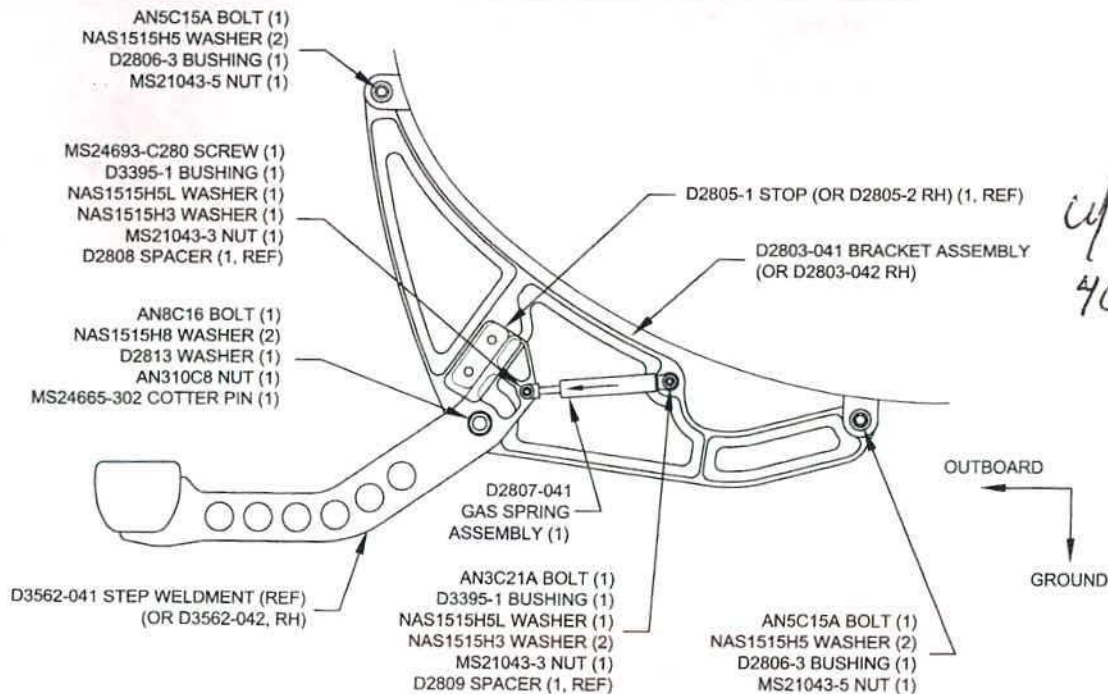
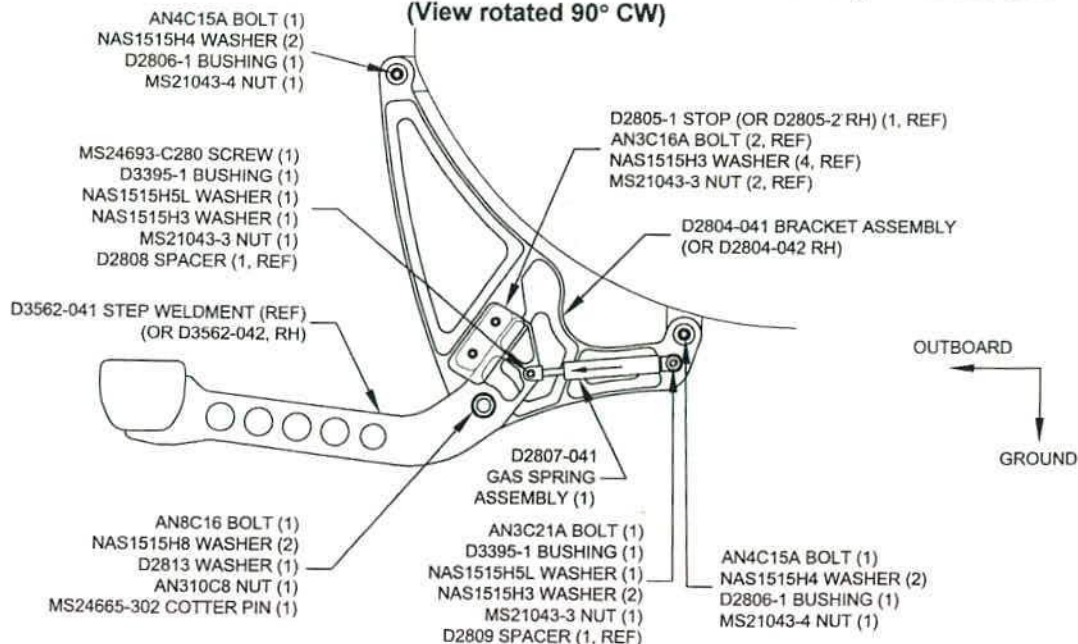
Job Completion



u 08-09-02

| Qty -033 | Qty -034 | Qty -243 | Qty -244 | Part Number | Description |
|-------------|-------------|-------------|-------------|--------------|---------------------------------|
| X | | | | D412-630-033 | HELI-ACCESS-STEP™ LH (FOLDING) |
| | X | | | D412-630-034 | HELI-ACCESS-STEP™ RH (FOLDING) |
| 1 | | X | | D412-630-243 | STEP ASSEMBLY LH |
| | 1 | | X | D412-630-244 | STEP ASSEMBLY RH |
| | | 1 | 1 | D2012-107 | CLEVIS |
| | | 1 | | D2803-041 | STA 84 BRACKET ASSEMBLY LH |
| | | | 1 | D2803-042 | STA 84 BRACKET ASSEMBLY RH |
| | | 1 | | D2804-041 | STA 155 BRACKET ASSEMBLY LH |
| | | | 1 | D2804-042 | STA 155 BRACKET ASSEMBLY RH |
| 2 | 2 | | | D2806-1 | BUSHING |
| 2 | 2 | | | D2806-3 | BUSHING |
| | | 2 | 2 | D2807-041 | GAS SPRING ASSEMBLY (WAS D2807) |
| 1 | 1 | | | D2810-5 | STRUT |
| | | 2 | 2 | D2813 | WASHER |
| | | 1 | | D3562-041 | STEP WELDMENT LH |
| | | | 1 | D3562-042 | STEP WELDMENT RH |
| | | 4 | 4 | D3395-1 | BUSHING |
| 2 | 2 | | | D3396-1 | SPACER |
| | | 2 | 2 | AN3C21A | BOLT |
| 1 | 1 | | | AN4C6A | BOLT |
| 1 | 1 | | | AN4C10A | BOLT |
| 2 | 2 | | | AN4C15A | BOLT |
| 1 | 1 | | | AN44-C7A | EYEBOLT |
| 2 | 2 | | | AN5C15A | BOLT |
| | | 2 | 2 | AN8C16 | BOLT |
| | | 2 | 2 | AN310C8 | NUT |
| | | 2 | 2 | MS24665-302 | COTTER PIN (OR AN380C3-4) |
| | | 6 | 6 | NAS1515H3 | WASHER |
| 7 | 7 | | | NAS1515H4 | WASHER |
| 7 | 7 | | | NAS1515H5 | WASHER |
| | | 4 | 4 | NAS1515H5L | WASHER |
| | | 4 | 4 | NAS1515H8 | WASHER |
| | | 4 | 4 | MS21043-3 | NUT |
| 4 | 4 | | | MS21043-4 | NUT |
| 3 | 3 | | | MS21043-5 | NUT |
| | | 2 | 2 | MS24693-C280 | SCREW (OR MS24694-C565) |

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WITHOUT NOTICE
WORK ORDER
NO. 40998

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)

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